Work Order ID 112622

112622

February-03-14 7:43:11 AM

Item ID: D206-642-641 **Accept** *N9000401000* **Setup Start** *NS1*

Revision ID:

Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Stop** *NS2*

Start Date: 2/03/14 **Start Qty:** 1.00 *1*

Required Date: 2/11/14 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3288	Rev H								
100		0.00							

100

DC

Document Control

Memo 0.00

Photocopy bluefile and create labels per PPP D206-642-641
CHG004

MA 14-02-14

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr FWD edge of tube,grind bending marks.								
	2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.								
	3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit A/R AL ROD Batch: m1278269/m122324								
	4-Grind welds flush to cap on top surface onlly.								
	5-Cut Aft end as per Dwg D3288 from front of tube then deburr								
	6-Remove inner indexing ridge on aft end as per Dwg d3288								
	7-Open holes for aft cap as per Dwg D3288 using Dt8025								
	8-Drill pilot holes using DT8818								
	9- open float holes section J-J (6 per side) to 0.297" and aft cap holes to 0.208"								
	10-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the 3/16" holes cleco D3286-1 doubler remove DT8879								
	11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify angle of holes to accomodate rivet heads.								
	12-Install DT8879 to hold doubler. Remove DT8732 then cleco doubler with #30 clecos. Remove DT8879 open GHW to 0.500"								

mm 14/03/02

DE 14/02/03

- DE 14/02/03

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID:
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Stop** *NS2*
Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	13-Remove D3286-1 doubler,identify orientation,deburr then attach to W/O								
	14-Remove indexing edge as per Dwg D3288.								
	15-C'sink rivet holes as per Dwg D3288.								
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				14-02-04			DAS 9 9-89
	Memo	0.00				14-02-04			DAS 9 9-89
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				1		14-24	
	Memo	0.00							

- DC 14/02/04

DAS 10 9-89

125 QC 9

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)
Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC7-Inspect Chemical Conversion Coat	0.00				1	Ø	DC 14/02/05	
140									
QC	**Memo**	0.00							
Quality Control									
150		0.00							
150									
Skidtubes	**Memo**	0.00							
Skidtubes	1-Open Holes to finished size as per DWg D3288.Deburr.								
	2-Locate, install and rivet doublers using DT8879 as per Dwg D3288. Micro-shave rivets as required.								
	3-Bond web in place as per Dwg D3288 & QSI 015.								
	A/RSikaflex-291 127918								
	Sikaflex expire date: 14/08/16								
	Start: 14/02/05 Time: 4:00								
	Finish: 14/02/10 Time: 11:00								
	(Adhere for 12 hours)								

- DC 14/02/05

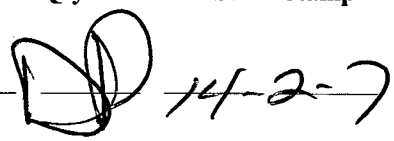
Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

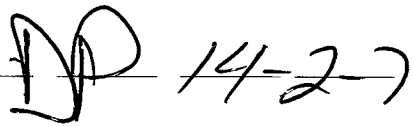
Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	**Memo**	0.00							
Quality Control									
170		0.00							
170									
CNC Bend 1	**Memo**	0.00							
CNC Delta 100 Bender	Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.								





Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00				DC	14/02/07		
180									
Skidtubes	**Memo**	0.00							
Skidtubes	1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid) DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) 2-C'sink X-bolt holes. 3-Deburr and remove alodine as required for welding								

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190									
Skidtubes	**Memo**	0.00							
Skidtubes	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod. A/RAluminum Rod M122324 BE 14/02/10 2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required A/RSS Rod NONE BE 14/02/10 3-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube 4-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.								
200	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
200						D 14.02-10			
QC	**Memo**	0.00							
Quality Control									

14-2-10

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
210						10	14-02-10		
QC	**Memo**	0.00							
Quality Control									
220	Pressure Wash per QSI005 4.3	0.00							
220						1	JB 14-2-11		
HandFinish	**Memo**	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
230		0.00							
230						1	C.R/AB	14-2-13	
SprayPaint	**Memo**	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 126 543								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 128 609								

Item ID: D206-642-641 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC14- Inspect Spray Paint	0.00				1			14.02.14
240									
QC	**Memo**	0.00							
Quality Control									
250		0.00				1x	4		14.02.14
250									
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS PROCYON A/R LPS PROCYON Batch: M122900 2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes A/RSikaflex-291 M127518 Sikaflex expire date: 1410								
260	QC5- Inspect part completeness to step on W/O	0.00				1	0	14-2-14	DAS 34 9-89
260									
QC	**Memo**	0.00							
Quality Control									

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00				14	1	11	14 Oct 14
270									
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install wearshoes/wearpads & Gaskets as per Dwg D3288.								
	2-Install Ring on Nut Plate as per detail F & Dwg D3288.								
	3-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 M12714 Sikaflex expire date: 14 Oct								
	4-Coat all exposed fastners with LPS Procyon,remove any exess on powder coat with MEK Degreasser. A/R LPS Procyon Batch: M12290e								
280	QC5- Inspect part completeness to step on W/O	0.00				1			
280									
QC	**Memo**	0.00							
Quality Control									

14/2/14

Item ID: D206-642-641 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 2/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290		0.00				1	8	14-02-14	
290									
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-641 Location: _____ PPP Rev: _____ PPP 112618								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	**Memo**	0.00							
Quality Control								14-02-14	MF 14-2-14

Picklist Print

February-03-14 7:43:10 AM

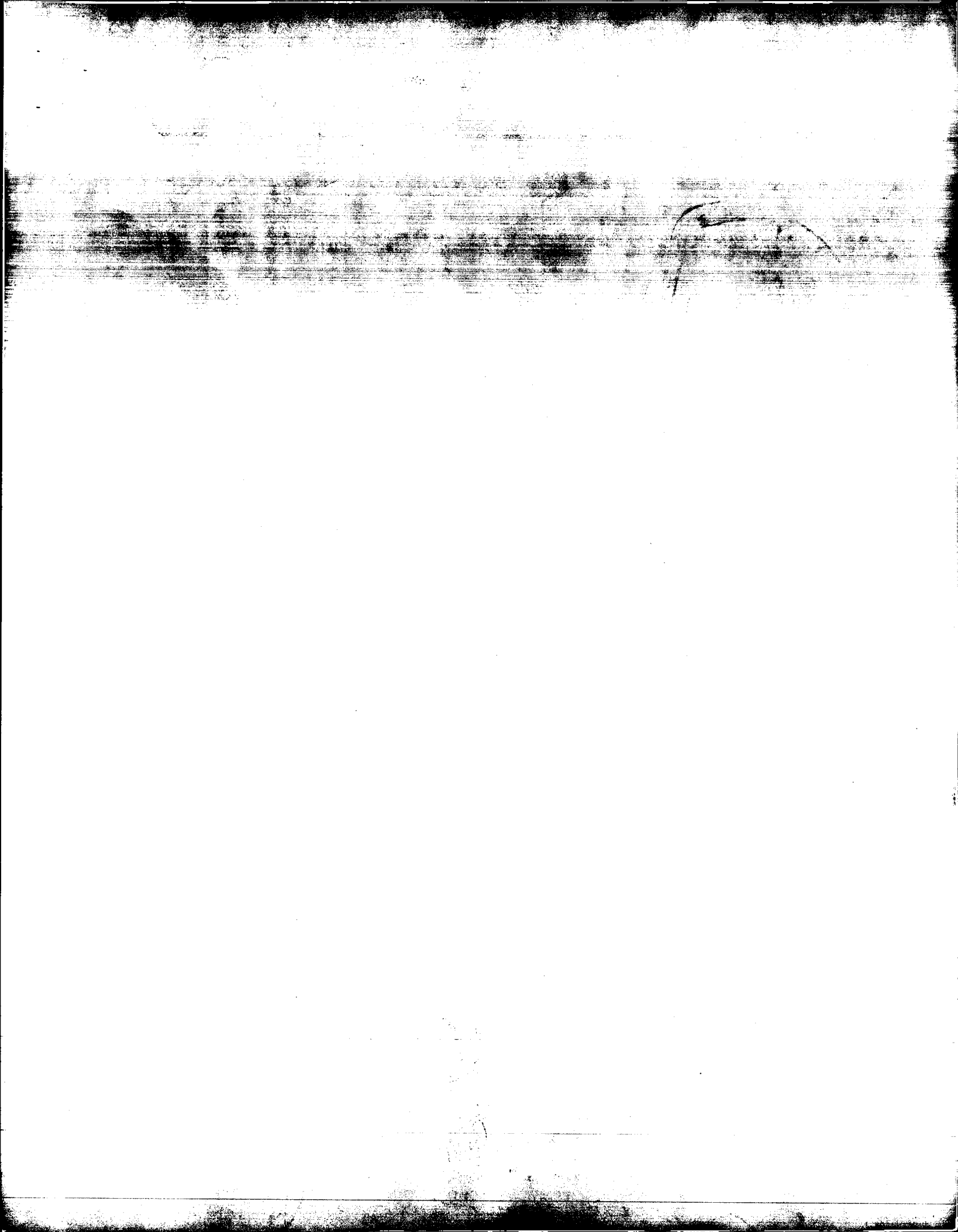
Work Order ID: 112622

Parent Item: D206-642-641 **Start Date:** 2/03/14 **Required Date:** 2/11/14

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

Comments: IPP Rev:B05.11.15Added washers for aft cap, wearshoes and ringEC
IPP Rev:C 06-05-31 Revised steps JLM
IPP Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM IPP Rev:E 07-12-06 ECN 1080p DD verified by:ec
IPP Rev:F 08-04-17 as per PAR 08-015 DD verified by: IPP REV:G 13.09.05 CHG004/ ECN13-634 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 Skidtube, 206 Skidtube		Manufactured	No			110	Each	20.0000	1	1	mm	14/03/02	
				Location		**Loc Qty**		**Loc Code**					
				LG		20							
				110799		20			1				
D2647 Cap		Manufactured	No			110	Each	11.0000	1	1		DC 14/02/03	
				Location		**Loc Qty**		**Loc Code**					
				LG001		11							
				102371		1							
				107588		10			1				
D3286-1 Doubler		Manufactured	No			110	Each	85.0000	2		DC 14/02/03		
				Location		**Loc Qty**		**Loc Code**					
				LG001		85							
				90503		2							
				91158		83			2				
CR3212-4-04 Cherry Rivet		Purchased	No			150	Each	548.0000	52	52	DC 14/02/05		
				Location		**Loc Qty**		**Loc Code**					
				ST327		98							
				123265		98							
				st552		450							
				m126534		10							
				m126691		440			62				



Picklist Print

February-03-14 7:43:10 AM

Work Order ID: 112622

Parent Item: D206-642-641 **Start Date:** 2/03/14 **Required Date:** 2/11/14

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

D3289-041 Float Web (206A/B)	Manufactured	No		150	Each	1.0000	1	1 2/14/06
			Location B112615	**Loc Qty**		**Loc Code**		(1)
			LG002	1				
			105270	1				
D2649 Cross Bolt Spacer	Manufactured	No		190	Each	327.0000	9	9 BE140210
			Location	**Loc Qty**		**Loc Code**		
			LG001	327				
			107906	145				9
			108633	176				
			90497	6				
D3275-1 Crossbolt Spacer	Manufactured	No		190	Each	186.0000	6	6 BE140210
			Location	**Loc Qty**		**Loc Code**		
			LG001	186				
			104849	21				
			107892	39				6
			109096	126				
D3286-3 Spacer	Manufactured	No		190	Each	123.0000	2	2 BE1402-10
			Location	**Loc Qty**		**Loc Code**		
			LG001	123				
			109097	61				
			91160	62				2
D3415-041 Nut Plate	Manufactured	No		250	Each	31.0000	1	1 2/14
			Location	**Loc Qty**		**Loc Code**		
			ST042	31				
			106195	31				VI

Picklist Print

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Work Order ID: 112622
Parent Item: D206-642-641
Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14 **Required Date:** 2/11/14
Start Qty: 1.00 **Required Qty:** 1.00

CCR264SS3-3 Cherry Rivet	Purchased	No		250	Each	296.0000	2	2 14/02/14

Location	Loc Qty	Loc Code	
ST327	296		
m126282	132		x2
m126333	164		

CR3212-4-03 Cherry Rivet	Purchased	No		250	Each	1,183.0000	2	2 14/02/14

Location	Loc Qty	Loc Code	
ST327	1083		
114889	1		
119017	700		
m123265	382		
st552	100		x2
m114859	100		

ALS7-1032-130 Rivnut	Purchased	No		250	Each	856.0000	64	64 14/02/14

Location	Loc Qty	Loc Code	
FG	100	M128211	x64
121444	100		
ST279	756		
119530	73		
122763	22		
124226	50		
m126109	611		

D3535-15 Stainless Steel Wearplate Fwd	Manufactured	No		270	Each	15.0000	1	1 14/02/14

Location	Loc Qty	Loc Code	
FP002	15		
106776	2		
110201	13		x1

Work Order ID: 112622

Parent Item: D206-642-641 **Start Date:** 2/03/14 **Required Date:** 2/11/14

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

D3535-21 Stainless Steel Wearplate Center Fwd	Manufactured	No		270	Each	5.0000	1	1

Location	Loc Qty	Loc Code
FP001	5	
102342	5	

D3535-35 Stainless Steel Wearplate Aft	Manufactured	No		270	Each	5.0000	1	1

Location	Loc Qty	Loc Code
FG	2	B1107763
94685	2	
FP002	3	
108053	3	

D3535-41 Stainless Steel Wearplate Center Aft	Manufactured	No		270	Each	7.0000	1	1

Location	Loc Qty	Loc Code
FP002	7	
42256	7	

D3536-15 Gasket Fwd	Manufactured	No		270	Each	17.0000	1	1

Location	Loc Qty	Loc Code
FG	4	
85604	2	
93893	2	
FP001	13	
107965	1	
110698	12	

D3536-21 Gasket Center	Manufactured	No		270	Each	7.0000	1	1

Location	Loc Qty	Loc Code
FP001	7	
104203	7	

Work Order ID: 112622

Parent Item: D206-642-641 **Start Date:** 2/03/14 **Required Date:** 2/11/14

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

D3536-35 Gasket Aft	Manufactured	No		270	Each	14.0000	1	1 14/02/14

Location	Loc Qty	Loc Code	
FG	6		
89650	2		
93911	4		
FP001	8		
109783	8		X1

D3536-41 Gasket Center Aft	Manufactured	No		270	Each	9.0000	1	1 14/02/14

Location	Loc Qty	Loc Code	
FP001	9		
51646	9		X1

D3537-1 Wearpad	Manufactured	No		270	Each	18.0000	7	14/02/14

Location	Loc Qty	Loc Code	
FG	18	B110821	X7
79833	8		
88562	10		

D3537-3 Wearpad	Manufactured	No		270	Each	21.0000	1	14/02/14

Location	Loc Qty	Loc Code	
FG	8	B111825	X1
86237	8		
FP002	13		
103014	13		

Work Order ID: 112622

Parent Item: D206-642-641 **Start Date:** 2/03/14 **Required Date:** 2/11/14

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

AN3C4A Bolt	Purchased	No		270	Each	2,802.0000	66	66 14/02/14

Location		Loc Qty	Loc Code	
FG		20		
	122814	20		
ST513		2782		
	125388	1835		
	M127410	447		
	M127832	500		X66

NAS1515H3L Washer	Purchased	No		270	Each	440.0000	2	2 14/02/14

Location		Loc Qty	Loc Code	
FG		40		
	102472	40		X2
ST297		400		
	m127831	400		

NAS1149C0332R WASHER	Purchased	No		270	Each	10,120.000	78	78 14/02/14

Location		Loc Qty	Loc Code	
GA		1185		
	125654	1185		
st510		8935		
	m126319	1059		X78
	m127306	2500		
	m127410	3000		
	m127831	2376		

D3683-1 Insert	Manufactured	No		270	Each	4,066.0000	12	12 14/02/14

Location		Loc Qty	Loc Code	
FP001		4066		
	36319	4066		X12

Work Order ID: 112622

Parent Item: D206-642-641 **Start Date:** 2/03/14 **Required Date:** 2/11/14

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

D3413-1 O-Ring	Manufactured	No		270	Each	25.0000	1	1

Location	Loc Qty	Loc Code	
ST464	25		
106048	7		
107984	16		x1
98167	2		

AN4C5A Bolt	Purchased	No		270	Each	114.0000	1	1

Location	Loc Qty	Loc Code	
ST355	114		
122599	44		x1
123265	20		
M127410	50		

NAS1149C0463R Washer	Purchased	No		270	Each	476.0000	1	1

Location	Loc Qty	Loc Code	
FP001	21		
119097	21		
ST292	455		
123248	1		
123355	154		x1
m127306	300		

D2646 Aft Cap	Manufactured	No		270	Each	23.0000	1	1

Location	Loc Qty	Loc Code	
FG	4		
85848	2	B110814	x1
90495	2		
FP001	19		
103306	18		
107857	1		

Work Order ID: **112622**
Parent Item: **D206-642-641** **Start Date:** 2/03/14 **Required Date:** 2/11/14
Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH) **Start Qty:** 1.00 **Required Qty:** 1.00

MS27039C1-05 SCREW	Purchased	No	270	Each	202.0000	**12**	**12**	Wlozl (c

Location	**Loc Qty**	**Loc Code**	
ST309	202		
107242	202		VIZ

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: – ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
   – PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 (H)
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: NONE
7. WEIGHT: 20.8 LBS
8. DAMAGE TOLERANCE ON FWD BEND:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
9. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
10. ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN.
11. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
13. WELDING: PER DART QSI 004.
14. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN OFF EXCESS GREASE WITH WASH 'N WIPE DEGREASER

w/o 11622

w 14-02-3

RELEASED
GP 13/4/4
ECN 13-567

REV.	DESCRIPTION	BY	DATE
H	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.21
G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D3288	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.21		

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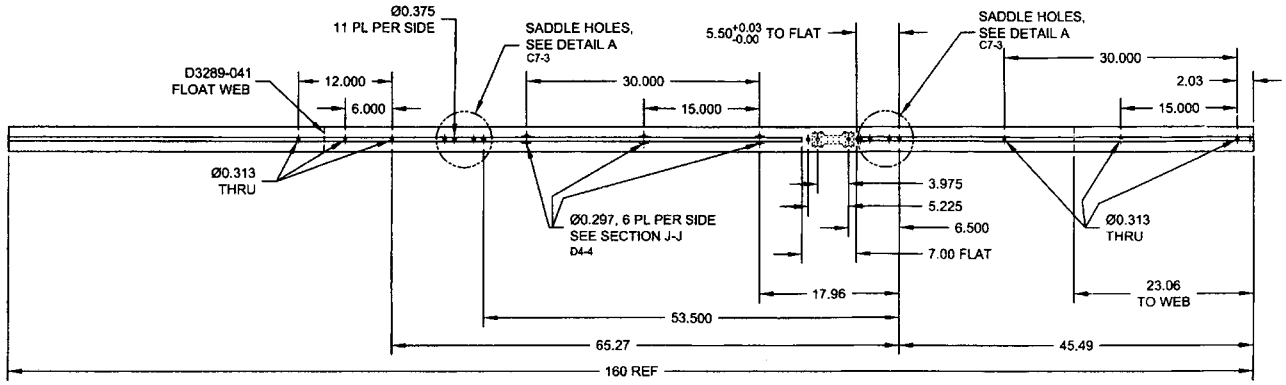
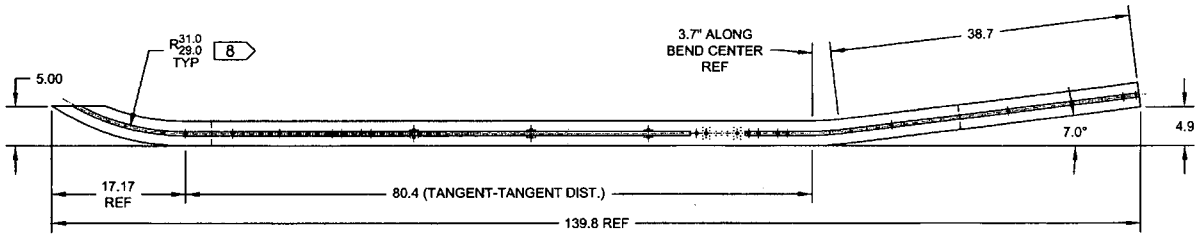
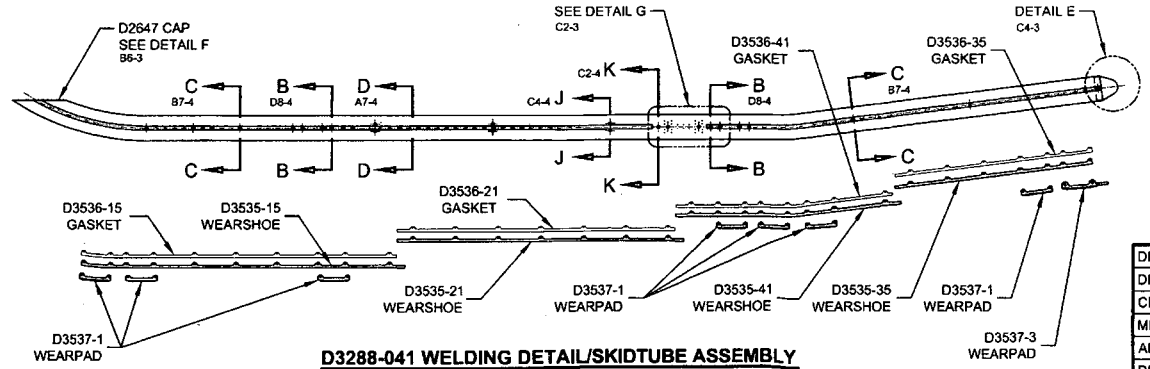


D3288-041 DRILLING/WEB ASSEMBLY DETAIL



D3288-041 BENDING DETAIL



D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

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CP 13/9/14

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D3288	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.21		

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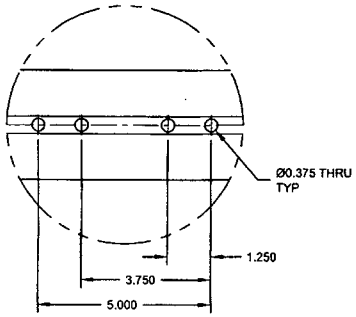
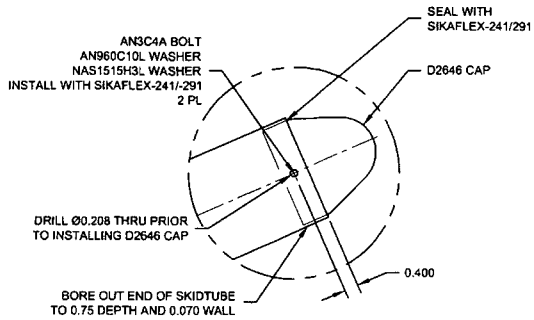
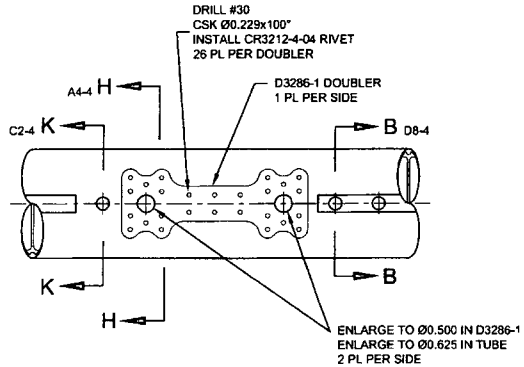


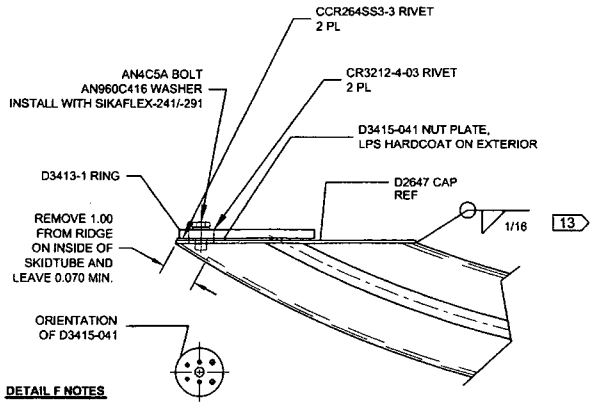
DETAIL A: DRILL DETAIL
SADDLE HOLES, SCALE 5X
D6-2, D4-2



DETAIL E
SCALE 5X
B3-2



DETAIL G
SCALE 5X
B5-2



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
   NOTE: MASK THREADS IN D3415-041
   PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL
B7-2 SCALE 5X

RELEASED
CP 13/9/14

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	DW	**HAWKESBURY, ONTARIO, CANADA**	
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D3288	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.21		

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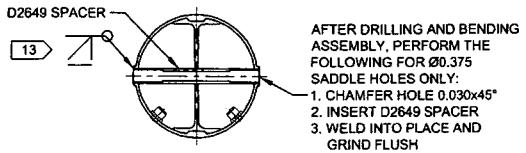
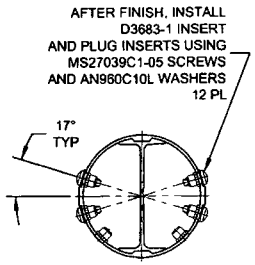


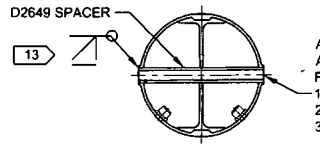
SECTION B-B

FOR Ø0.375 SADDLE HOLES ONLY
8 PL, SCALE 5X
B7-2, B5-2, D1-3



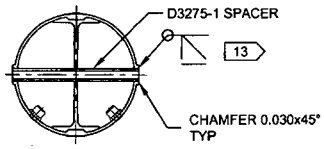
11 SECTION J-J

SCALE 5X
D5-2, B6-2



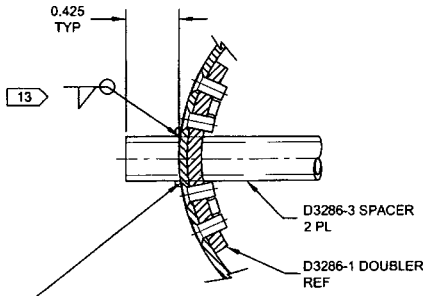
SECTION K-K

1 PL, SCALE 5X
B5-2



SECTION C-C

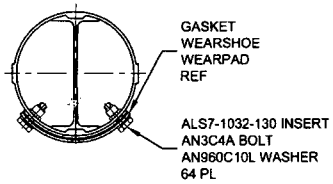
FOR Ø0.313 HOLES ONLY
6 PL, SCALE 5X



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

SECTION H-H

NOT TO SCALE
D3-3



12 SECTION D-D

FOR WEARSHOES INSTALL ONLY
32 PL, SCALE 5X
B6-2

RELEASED
13/9/4

DESIGN	CP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	DW	
CHECKED	AP	DRAWING NO. REV. H
MFG. APPR.	DD	D3288 SHEET 4 OF 4
APPROVED	MP	TITLE SCALE
DE APPR.		SKIDTUBE ASSEMBLY NTS
DATE 13.05.21		

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NO. 336

AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD

Name: barclay Elliott

Job #: 105007

Part #: D206-642-151

Description: 206 skid tube

Welding Process: TIG [✓] MIG [ ]

Base Material: Aluminium

Current: AC [✓] DC [ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass [✓] fail [ ]
Penetration:	pass [✓] fail [ ]
Fusion:	pass [✓] fail [ ]
Cracks:	pass [✓] fail [ ]
Overlap (cold lap)	pass [✓] fail [ ]
Undercut:	pass [✓] fail [ ]
Pin holes:	pass [✓] fail [ ]
Porosity (surface):	pass [✓] fail [ ]
Coloration:	pass [✓] fail [ ]
Burn through:	pass [✓] fail [ ]

Qualifier: DAS 9 ~~9-89~~ **Date of Test Coupon:** 13-11-14

Welder: Barclay Elliott **Date of Test Coupon:** 13-11-14

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.